










Date: Wednesday, 02/04/2008 11:27:38 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GUIDE ASSEMBLY
Job Number	: 38300		
Estimate Number	: 12709		
P.O. Number	:	Part Number	: D3572041
This Issue	: 02/04/2008 S.O. No. :	Drawing Number	: D3572 REV.C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : LARGE FAB ASSY	Drawing Revision	: C
Previous Run	: 31870	Material	:
Written By	:	Due Date	: 14/04/2008 Qty: 10 Um: Each
Checked & Approved By	: <u>JD 08.04.02</u>		
Comment	: Est Rev:A New Issue 07-02-07 JLM est rev B revB dwg EC Est Rev:C Removed D3572-7 Cap 07-06-11 JLM		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	D35723	GUIDE	
			
Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s) GUIDE Batch: <u>B 38324 → 40x 38</u> 08-04-24 SP 8			
2.0	D35725	BRACKET	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s) B 3245 → 1x. BRACKET Batch: <u>B 31913 → 7x</u> 08-04-24 SP 8			
3.0	M6061T6T1000W188	6061T6 TUBE 1.00 X .188W	
			
Comment: Qty.: 2.3405 f(s)/Unit Total: 23.4045 f(s) M 104779 → 11.70. 6061-T6 Round Tube 1.00"x 0.188 wall Batch: <u>M 104480 → 11.70</u> 08-04-24 SP 8			
4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
			
Comment: LARGE FABRICATION RESOURCE 1 1-Cut Tube D3572-1 as per Dwg D3572 2-Weld D3572-3 guides and D3572-5 bracket as per Dwg D3572 A/R AL ROD Batch: <u>M 104855</u> 08-04-24 SP 8			

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUIDE ASSEMBLY

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/25 (8)

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08-04-25 (8)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-F

04/0

13 3 8300
D3572041
29/04/2008

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M 105412

08-04-25

S.138 08.55
#1 316.0 F
#2 --- F
#3 30mm F
#4 --- F

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-F

08/04/29

(8X)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

52247

08/04/29 (8)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/30

Job Completion



M-F 08-04-30

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

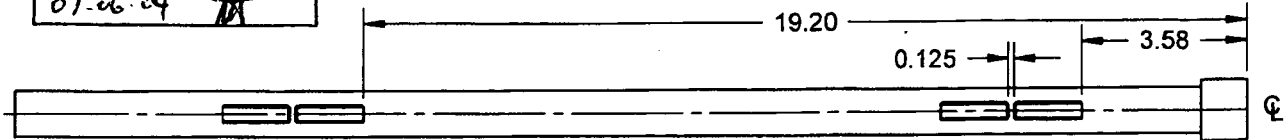
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3572	REV. C SHEET 1 OF 2
DATE 07.06.01	TITLE GUIDE ASSEMBLY		SCALE 1:4
REV	DATE	DESCRIPTION	
A	07.03.29	NEW ISSUE	
B	07.04.20	FOR D3573-3 0.03 CHMF WAS 0.06; ADD TYP TO FILLET	
C	07.06.01	REMOVE D3572-7	

RELEASED07.06.01 *H*D3572-3 GUIDE
(4 PLACES)

3/16

4X

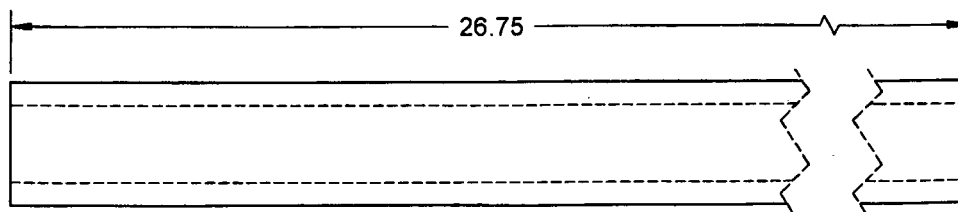
D3572-1 TUBE

D3572-041 GUIDE ASSEMBLY

D3572-5 BRACKET

D3572-041 NOTES:

- 1) PART IS SYMMETRIC ABOUT CENTERLINE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3572-041" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) WELD PER DART QSI 004

**D3572-1 TUBE**

0.188 (REF)

Ø 1.000 (REF)

D3572-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM TUBE 1.00 OD X 0.188 WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8
(REF DART SPEC M6061T6T1.000W.188)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

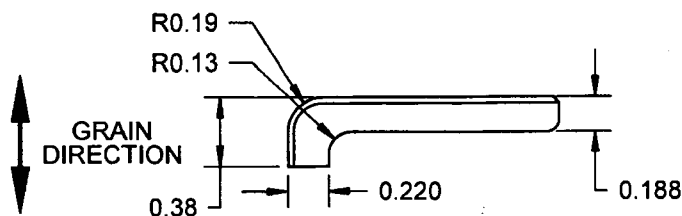
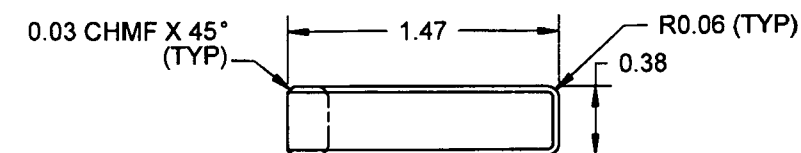
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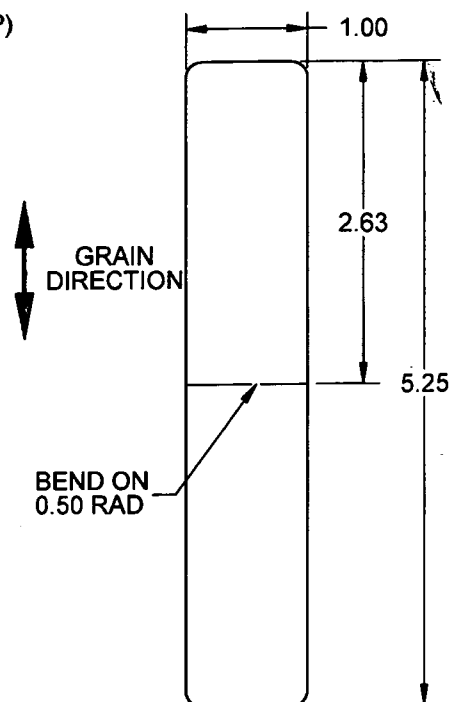
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WORK ORDER
NO. 38300



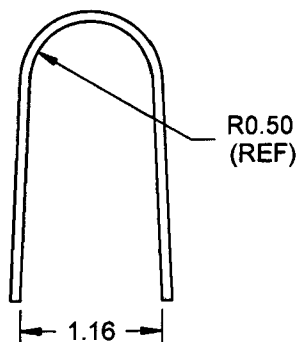
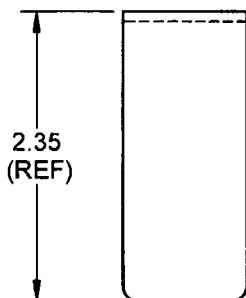
DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3572	REV. C SHEET 2 OF 2
DATE 07.06.01		TITLE GUIDE ASSEMBLY	SCALE 2:3



1 **D3572-3 GUIDE**



2 **D3572-5F FLAT PATTERN**



**D3572-5 BRACKET
(MAKE FROM D3572-5F)**

RELEASED

07.06.01 *H*

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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 38300

D3572-3/-5 NOTES:

- 1) D3572-3 MATERIAL: 6061-T6 (OR T651/T6510/T651/T62) ALUMINUM BAR
PER QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 (OR AMS 4160) (REF DART SPEC M6061T6B)
- 2) D3572-5 MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK PER QQ-A-250/11
OR AMS 4025 OR 4027 (REF DART SPEC M6061T6S.080)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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